

Work Order ID 51148

August 31, 2009 1:02:29 PM



Page 1

Item ID: D3684-049

Accept



Setup Start



Revision ID: C

Stop



Item Name: AFT LEG ASS'Y

Start Date: 08/21/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *09-08-31*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3684	Rev C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684								
	2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684								
	***Ensure holes for AN3C Bolts are free of sealant. Torque Fastners as per Dwg D3684								

SB 09/08/31 4 *08*

SB 09/09/01

Picklist Print

August 31, 2009 1:02:29 PM

Page 1

4

Work Order ID: 51148



Parent Item: D3684-049RevC



Parent Item Name: AFT LEG ASS'Y

Start Date: 08/21/2009

Required Date: 08/28/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A 		Purchased	No			110	Each	455.0000	8.0000			
Bolts												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	455	
106993	7	
110155	2	
110552	3	
110584	23	
111916	20	
112314	400	

SB 09/09/01 (4)

D3688-3RevB



Manufactured No

110 Each 16.0000 4.0000



STUD

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	16	
44824	6	
45671	2	
50936	8	

SB 09/09/01 (4)

Picklist Print

August 31, 2009 1:02:29 PM

Page 2

Work Order ID: 51148

Parent Item: D3684-049RevC

Parent Item Name: AFT LEG ASS'Y



Start Date: 08/21/2009

Required Date: 08/28/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3689-1RevB		Manufactured	No			110	Each	12.0000	4.0000			
												
SLEEVE												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

46051

2

Main Warehouse

ST125

10

50388

10

D3691-1RevU/R

Manufactured

No

110

Each

12.0000

4.0000



STUD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

12

46052

8

50721

1

50722

3

SB 09/09/01 (4)

* SB 09/09/01 (4)

August 31, 2009 1:02:29 PM

Shop Packet Print

Page 2

Picklist Print

August 31, 2009 1:02:29 PM

Page 3

Work Order ID: 51148

Parent Item: D3684-049RevC

Parent Item Name: AFT LEG ASS'Y

Start Date: 08/21/2009

Required Date: 08/28/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3692-1RevB		Manufactured	No			110	Each	752.0000	16.0000			
SPACER												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 59

44827 8

45672 14

50325 37

Main Warehouse

ST127 693

50736 285

51467 408

SB 09/09/01 (4)

16

D3693-1RevU/R

Manufactured No

110

Each

94.0000

8.0000



Rod End Bearing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 5

45723 5

Main Warehouse

ST127 89

50733 10

50734 79

SB 09/09/01 (4)

8

August 31, 2009 1:02:29 PM

Shop Packet Print

Page 3

Picklist Print

August 31, 2009 1:02:29 PM

Work Order ID: 51148

Parent Item: D3684-049RevC

Parent Item Name: AFT LEG ASS'Y



Start Date: 08/21/2009

Required Date: 08/28/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3 		Purchased	No			110	Each	5,350.000	8.0000			
Nut												

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 80

103691 80

Main Warehouse

ST 5270

111819 82

112243 212

112314 4976

NAS509L12C

Purchased

No

110

Each

88.0000

4.0000



Nuts



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 88

106993 2

110844 4

112314 82

SB 09/09/01

8

SB 09/09/01

1/3

pro next page

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
04/08/29	110	add NAS 509-12 e M 112453	SB	4/18/31	4		S 02/09/16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

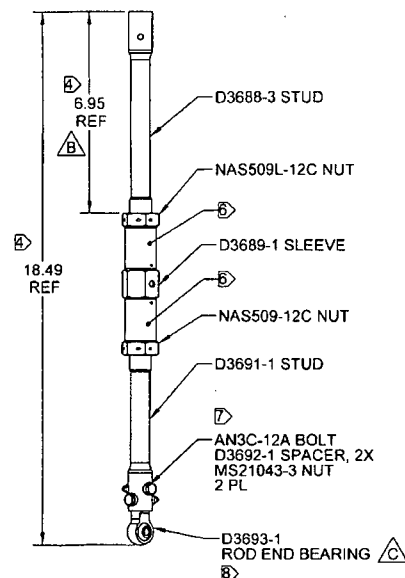
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
2	Drill Lab	pull from stock 1x D3687-1 B45911 1x D3687-1 B467604 B45911(1) 2x D3684.043 B51144	SB	09/08/28	1 24 + 1 2
3	DC5	drill tab to #261 per NCR 49.084/80 Inspect → Seal 08/28/80 to 09/01/80 if used Pillows Block to ensure hole align. 1x +1	SB	09/08/28	4 4
4	PK	Return to stock using original B/N	SB	09/09/01	5
5	DC21	Inspect Level 21 * Add copy of this w/o to each of above			

H:\Forms\Quality Assurance\Approved QA\PPSHORT revA

ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-049 AFT LEG ASSEMBLY

#51148
MF
09-08-04

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.88 lbs
- 6) USE TECTYL 502C CLASS 1, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
09/01/12 MF

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3684	SHEET 5 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TRIPOD MOUNT ASSY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND/OR CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries